

# Work Order ID 70457-2

Wednesday, June 08, 2011 7:39:31 PM



Page 1

Item ID: D2572

Revision ID:

Item Name: Saddle, Fwd In 205

Start Date: 6/16/2011 Start Qty: 12.00

Required Date: 6/28/2011 Req'd Qty: 12.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2572	Rev E								

100



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

0.00

Memo

0.00

Program Batch No. 70457

Double check by: H.O.

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and insp

SL 11/06/20

(5)

φ

110



Mill Conv

Conventional Milling Machine

CONVENTIONAL MILLING MACHINE

0.00

Memo

0.00

Machine keyway as per dwg D2571 & D2572

SL 11/06/20

(5)

φ

**Work Order ID 70457**

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Page 2

Item ID: D2572

Accept



Setup Start



Revision ID:

Item Name: Saddle, Fwd In 205

Stop



Start Date: 6/16/2011 Start Qty: 12.00



Required Date: 6/28/2011 Req'd Qty: 12.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

SL 11/06/20

Memo

0.00

5

φ

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

B.A 11/06/21

Memo

0.00

5

φ

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

5

BR 11-6-21.

**Work Order ID 70457**

Wednesday, June 08, 2011 7:39:31 PM



Page 3

Item ID: D2572

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, Fwd In 205

Start Date: 6/16/2011 Start Qty: 12.00



Required Date: 6/28/2011 Req'd Qty: 12.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150



Powdercoat

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

7:15  
320  
7:45

0.00

5x ~~OK~~ M-11/06/22

Powder Coating

N1116964

160



QC

QC3- Inspect Part Finish

0.00

Memo

0.00

5 ~~OK~~ BL 11-6-22.

Quality Control

170



Packaging

Identify as per dwg &amp; Stock Location: 433

0.00

Memo

0.00

JB ~~OK~~ 11/06/22

Packaging

**Work Order ID 70457**

Wednesday, June 08, 2011 7:39:31 PM



Page 4

Item ID: D2572

Revision ID:

Accept



Setup Start



Item Name: Saddle, Fwd In 205

Stop



Start Date: 6/16/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 6/28/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/22

mf

11-06-22



# Picklist Print

Wednesday, June 08, 2011 7:39:28 PM

Page 1

Work Order ID: 70457

Parent Item: D2572

Parent Item Name: Saddle, Fwd In 205



Start Date: 6/16/2011

Required Date: 6/28/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: I02.10.02 Re-format; Change to Dwg Rev. D & incorporated  
D2572 KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-005  Saddle Billet		Manufactured	No			100	Each	63.0000	1	12		2 11/06/20	

## Location

## Loc Qty

## Loc Code

MAT045

27

66966

27

MAT046

36

65382

11

65953

16

66966

9

\_\_\_\_\_  
\_\_\_\_\_  
7  
5

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	<b>70457</b>
<b>Description:</b> Saddle, Fwd Inboard		<b>Part Number:</b>	<b>D2572</b>
<b>Inspection Dwg:</b> D2572 Rev. E			
		<b>Page 1 of 1</b>	

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.500	.501	.502	.502		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.500	.500	.500	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.568	.568	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.125	.125	.125	.127		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.251	.251	.251	.251		
S	0.115	0.135		.127	.127	.127	.130		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.241	.241	.241	.240		
W	0.115	0.135		.122	.122	.123	.120		
X	0.307	0.312		.310	.310	.309	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.362	.363	.364	.362		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	.625	.626	.625		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.249	.250	.251	.248		
AE	1.375	1.395		1.387	1.386	1.387	1.387		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.270	.270	.270	.270		
AH	0.240	0.260		.250	.250	.250	.248		
AI	2.000	2.020		2.003	2.001	2.002	2.002		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	<b>SL</b>
Date:	<b>11/06/15</b>

Audited by:	<b>hna</b>
Date:	<b>11/06/21</b>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	<b>70457</b>
<b>Description:</b> Saddle, Fwd Inboard		<b>Part Number:</b>	<b>D2572</b>
<b>Inspection Dwg:</b> D2572 Rev. E		<b>Page 1 of 1</b>	

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				15	16	17	18		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.001	8.001	8.002		
F	0.490	0.510		.494	.498	.502	.498		
G	0.257	0.262		.259	.257	.257	.257		
H	0.375	0.380		.376	.376	.376	.376		
I	0.490	0.510		.500	.500	.503	.501		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.566	.569	.569		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.875	3.874	3.874	3.874		
P	0.115	0.135		.127	.128	.128	.128		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.257	.253	.253	.252		
S	0.115	0.135		.130	.128	.133	.132		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.959	2.960	2.960	2.960		
V	0.230	0.250		.241	.243	.244	.243		
W	0.115	0.135		.124	.130	.130	.129		
X	0.307	0.312		.310	.311	.310	.312		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.364	.363	.363	.366		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.624	.627	.626	.625		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.245	.252	.252	.250		
AE	1.375	1.395		1.387	1.386	1.386	1.387		
AF	0.115	0.135		.135	.125	.125	.125		
AG	0.240	0.280		.250	.260	.260	.260		
AH	0.240	0.260		.250	.253	.252	.252		
AI	2.000	2.020		2.005	2.005	2.005	2.008		
AJ	0.023	0.043		.033	.035	.035	.035		
Accept/Reject									

Measured by:	<i>[Signature]</i>
Date:	11/06/20

Audited by:	<i>[Signature]</i>
Date:	11/06/21

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>[Signature]</i>



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	<b>70457</b>
<b>Description:</b> Saddle, Fwd Inboard		<b>Part Number:</b>	<b>D2572</b>
<b>Inspection Dwg:</b> D2572 Rev. E		<b>Page 1 of 1</b>	

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				99	910	911	912		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.495	.499	.501	.499		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.500	.501	.500	.499		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.567	.568	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.125	.125	.125	.125		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.252	.251	.251	.251		
S	0.115	0.135		.129	.128	.128	.127		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.242	.241	.242	.242		
W	0.115	0.135		.122	.122	.124	.125		
X	0.307	0.312		.310	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.362	.363	.361	.362		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	.625	.625	.625		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.249	.248	.249	.250		
AE	1.375	1.395		1.387	1.387	1.388	1.387		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.270	.270	.270	.270		
AH	0.240	0.260		.250	.250	.250	.251		
AI	2.000	2.020		2.002	2.002	2.003	2.002		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	<u>SL</u>
Date:	<u>11/06/20</u>

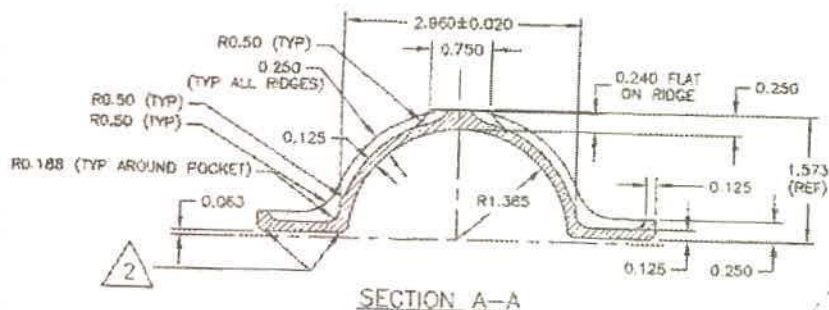
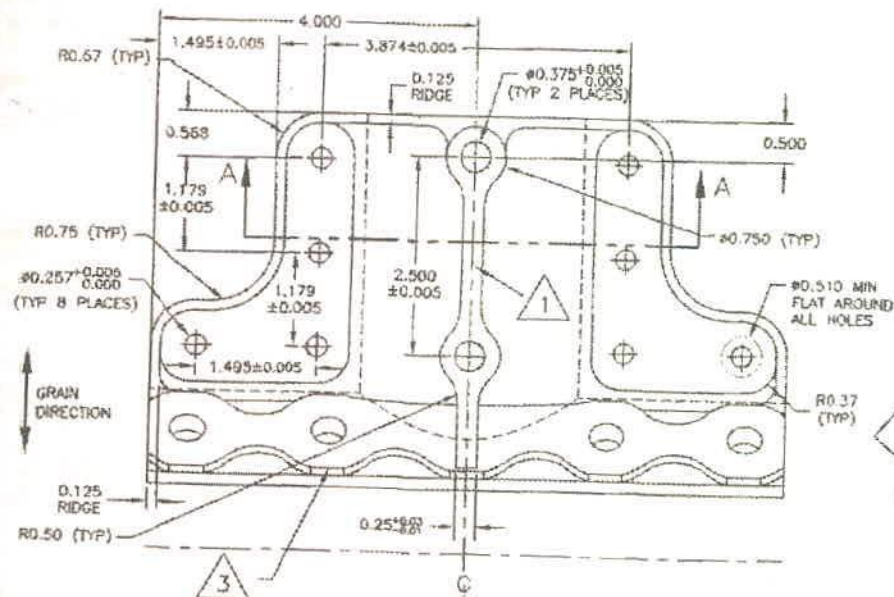
Audited by:	<u>HA</u>
Date:	<u>11/06/21</u>

Rev	Date	Change	Revised by	Approved
A		New Issue		
B	02.09.24	Re-format; Added Rev. D	RF	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ	
E	05.12.05	Added dimension AJ	KJ/RF	
			KJ/JLM	

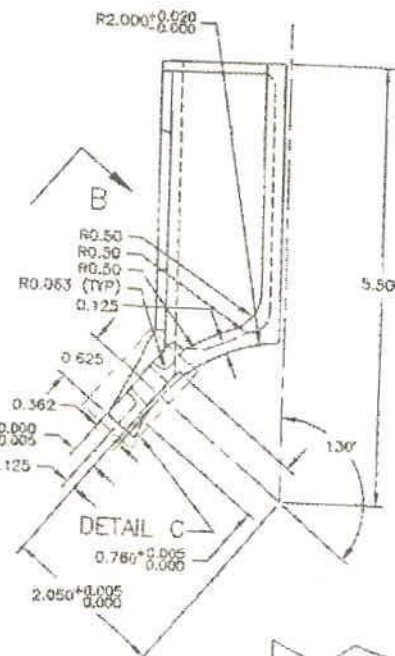


RELEASED

05.12.06



SECTION A-A



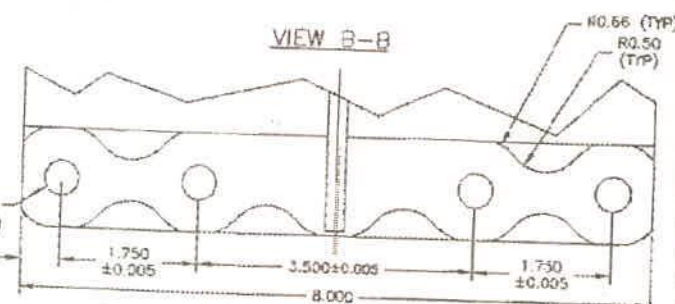
DETAIL C

## NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)  
 (REF DART SPEC. D6102-003)  
 FINISH: ACID ETCH, ALDINE PER DART QSI 005 4.1  
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
 DART QSI 005 4.3  
 BREAK ALL SHARP EDGES 0.010 TO 0.020  
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010  
 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)  
 3 CHAMFER 0.063 x 45° ALL AROUND  
 4 CHAMFER 0.033 x 45° (SEE DETAIL C) E

VIEW B-B

DETAIL C  
SCALE 2:1

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 OR COPIED OR COMMUNICATED TO ANY OTHER  
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 DART AEROSPACE LTD.

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCOMP. DEC 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR. 0.438 WAS C.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	05.07.13	DRAWING NO. D2572
		TITLE INVER FWD SADDLE
		REVISION 1
		SHEET 1 OF 1
		SCALE 2:1

DART

DART AEROSPACE LTD.

MANCHESTER, GLOUCESTER, ENGLAND